

Date: Wednesday, 9/12/2007 12:13:10 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RING	
Job Number	: 34595		Part Number	: D2655UP	
Estimate Number	: 12922		Drawing Number	: D2655 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 9/12/2007 S.O. No. : N/A		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 9/30/2007 Qty: 20 Um: Each	
Previous Run	: 34187				
Written By					
Checked & Approved By					
Comment	: Est Rev.A New Issue 07-07-04 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1018B400X250	Inventory
	Comment: Qty.: 0.2835 f(s)/Unit Total : 5.6700 f(s) 1018 ASTM A36 .250" thk bar x 4.0" Batch: M10S38 HB 07-09-13	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D2655 Dwg Rev: B Prog Rev: B	
	HB 07-09-13	
2.0	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	HB 07-09-13	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	20
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	En 07/09/24 (x20) counter
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Tumble - .030 Radius 2-Deburr any rough edges after tumbling	
		SAD 07/09/24 20

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/09/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 34595

Part Number: D2655UP

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 07/09/24 (20) counter

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/09/24 (20)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20 07/09/24 (20) Works

Job Completion



U 07-09-24

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-COMFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

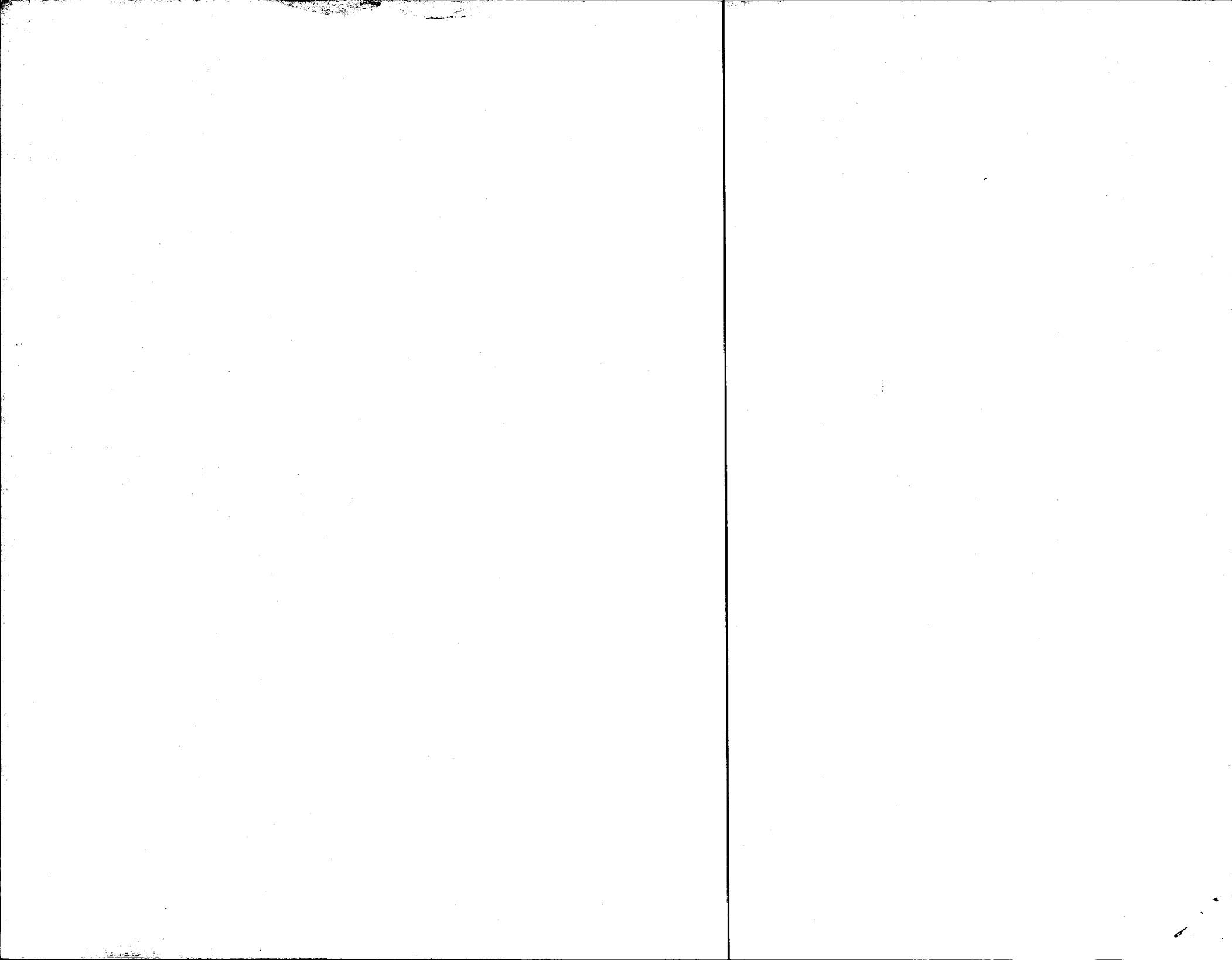
DART AEROSPACE LTD	Work Order:	34595
Description: Ring	Part Number:	D2655
Inspection Dwg: D2655	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article | Prototype

Measured by:	K3	Audited by:	S	Prototype Approval:	N/A
Date:	07-09-13	Date:	3/3/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.12	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

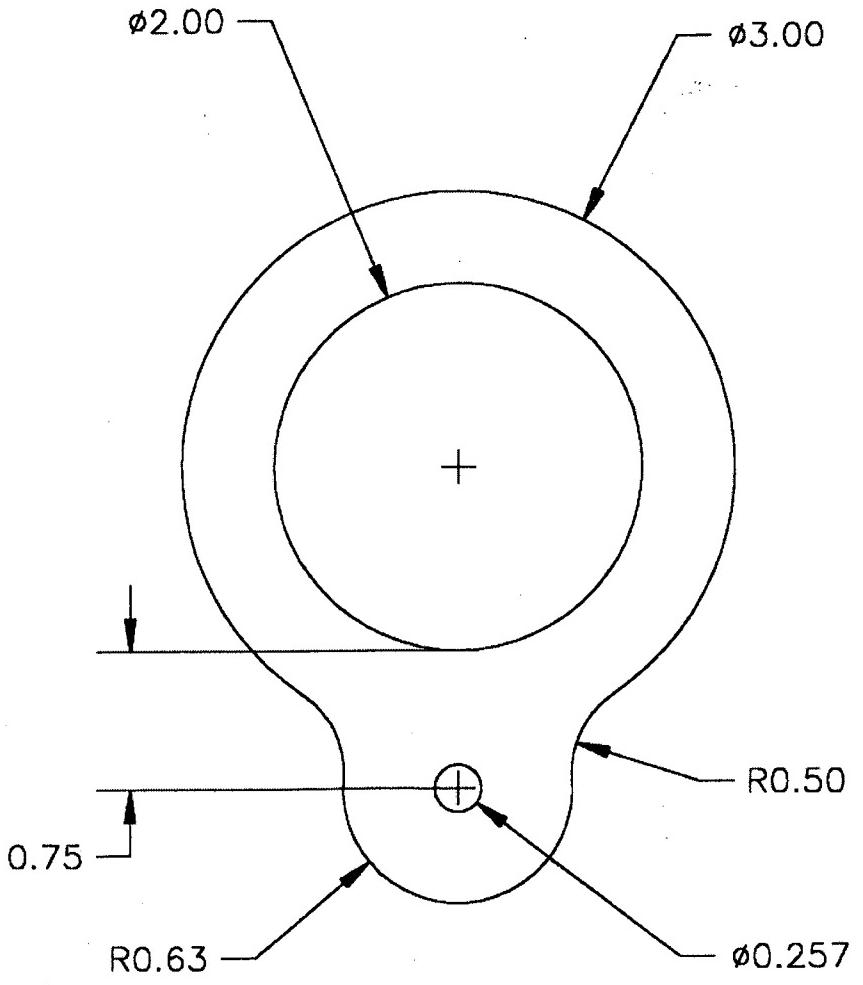




OF COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED	APPROVED	DRAWING NO. D2655 REV. B SHEET 1 OF 1
DATE		TITLE RING SCALE 1:1
97:07:07		
A	97:03:25	NEW ISSUE
B	97:07:07	ADD ASTM A36 TO MAT. SPEC.

RELEASED
47/07/97 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34595

NOTE: DEBURR ALL SHARP EDGES

MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK

FINISH: POWDER COAT PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

